

Date: Friday, 23/01/2009 8:47:40 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOOR DOUBLER
 Job Number : 45196
 Estimate Number : 13455
 P.O. Number :
 This Issue : 23/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D35945
 Drawing Number : D3594 REV B
 Project Number : N/A
 First Issue : / / Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 42267 Material :
 Due Date : 05/02/2009 Qty: 10 Um: Each
 Written By :
 Checked & Approved By : 20 09.01.23
 Comment : Est Rev :A New Issue 08.07.07 EC verified by DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



MAT NOT PULLED



Comment: Qty.: 0.0578 sf(s)/Unit Total : 0.5775 sf(s)

6061-T6 .080 Sheet

Batch: 104921 B 9-2-23

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3594

Dwg Rev: B

Prog Rev: B

B 9-2-23

2-Deburr if necessary

M. 09/02/23

(28)

(28X)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 9-2-23

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 09/02/23

(28) counter

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'SINK AS [PER dwg d3594

45 09/02/23 (28)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/01/2009 8:47:41 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 45196

Part Number: D35945

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sort 02/23 counter x28

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

09-02-21

x28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/02/25 x28

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST110

09/02/25 x28

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/25 x28

Job Completion



09/02/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

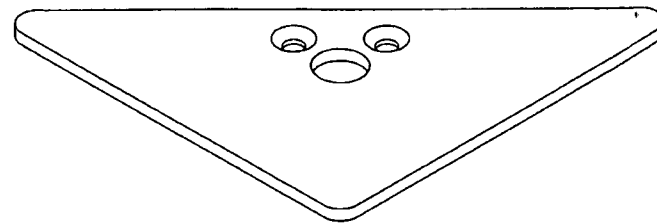
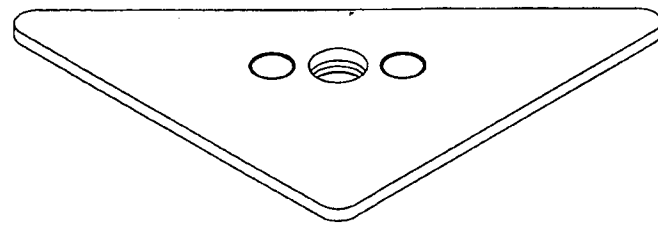
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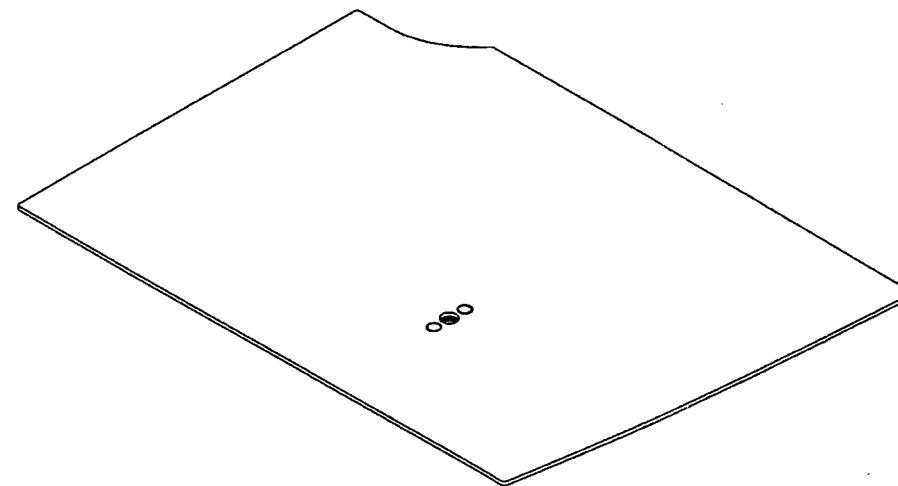
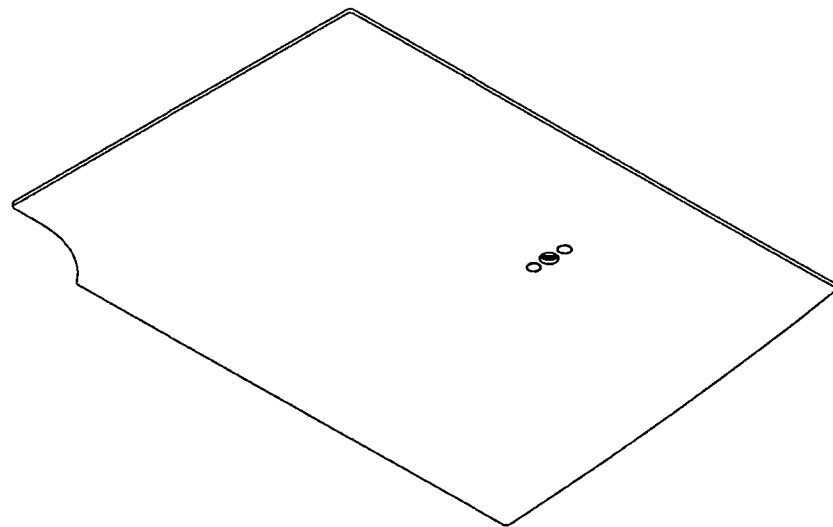


D3594-041 DOOR DOUBLER ASSEMBLY

D3594-5 DOOR DOUBLER

C

C



D3594-043 FLOOR DOUBLER ASSEMBLY

D3594-044 FLOOR DOUBLER ASSEMBLY

B

B

SHC COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45196

RELEASED
08.05.14

A

A

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.05.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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6

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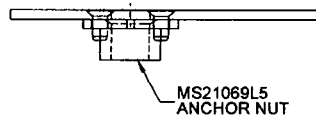
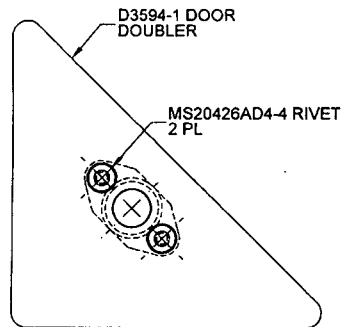
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2

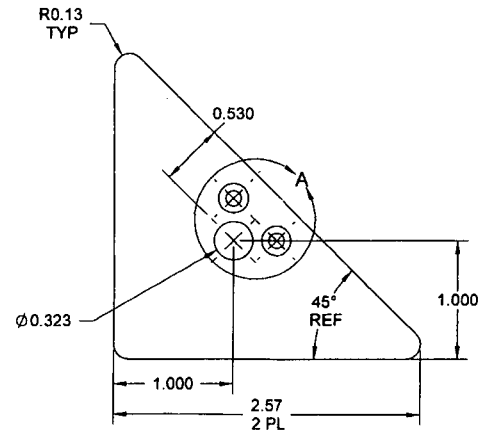
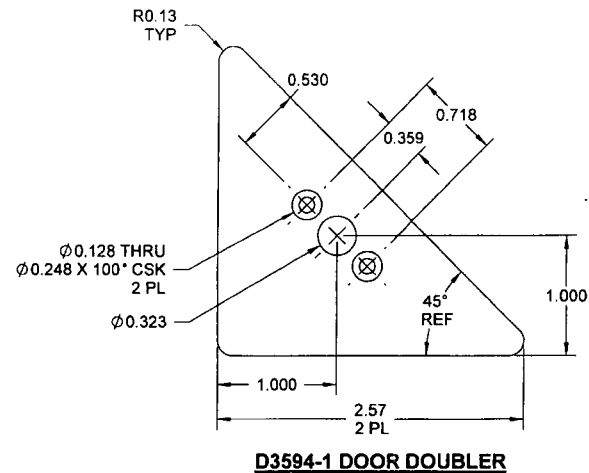
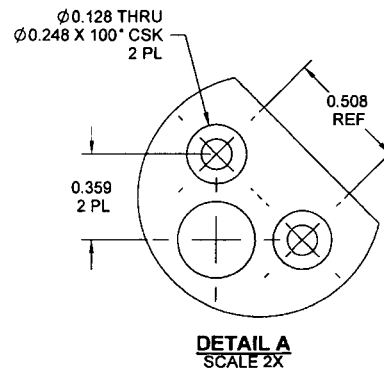
1

REFERENCE ONLY

QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



4 D3594-041 DOOR DOUBLER ASSEMBLY







NOTES:

- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

45796

RELEASED
08-06-26-14

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.05.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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